

Date: Thursday, 12/04/2007 7:52:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD TUBE ASSEMBLY
 Job Number : 31810
 Estimate Number : 10467
 P.O. Number : *N/A* Part Number : D3391021
 This Issue : 12/04/2007 S.O. No. : *N/A* Drawing Number : D3391 REV.F
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : F
 Previous Run : 31807 Material : *N/A*
 Written By : *[Signature]* Due Date : 19/04/2007 Qty: 1 Um: Each
 Checked & Approved By : *[Signature]*
 Comment : Est. A 05.09.13 New issue KJ/JLM
 Est. B 06.02.10 Dwg rev.D ecn 773 EC
 Est. C 06.05.02 Added inspections EC
 est D 07.03.13 rev F dwg EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6013047 SKIDTUBE MAT'L



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	<i>B26547 DP 2-4-12</i>

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 Cut extrusion to 46.52 +0.010 -0.020

DP 2-4-12

3.0 BENDING BENDING MACHINE



Comment: Nc bender
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-4-12

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 07-04-12

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *F*
 Identify as D3391-1

J.F. / J.L 07/05/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:52:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31810

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Debur

JF/JL 07/05/15

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF/JL 07/05/15

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

36 07.05.22

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

36 07.05.22

①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/05/22

①

10.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill one fwd cap hole to dia.0.128" per DWG D3391 one side only

N/A
already fixed.

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Debur

7-5-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:52:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31810

Part Number: D3391021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07/02/12 (41)

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AWM/lmc

07/07/24

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h 07/08/10

15.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

BR/M-h 07-08-16

①

16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/17 ①

17.0	NAS1330C3KB166	INSERT
------	----------------	--------



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

m/03279

07/08/24

FL/M-h

①

18.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

FL 07/08/17 ①

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:52:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31810

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tow Cap Assembly

Pick:

Qty	Part Number	Description	Batch
1	D3401-041	Tow Cap	

B 31346 M-L

21.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE

B 33800 M-L

22.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET

B 32660 M-L

23.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN3C4A	Bolt	

M 105143

M-L

~~M 104877~~

24.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3L	Washer	

M 104603

M-L

25.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

M 105143

~~M 104885~~

(IX)

M-L 07/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/04/2007 7:52:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31810

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

M-L 07/08/24

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

Dr 07/08/24

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPR B33973

07/08/12

29.0

QC21

FINAL INSPECTION/W/O RELEASE



(I)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/13

Job Completion



07-09-13

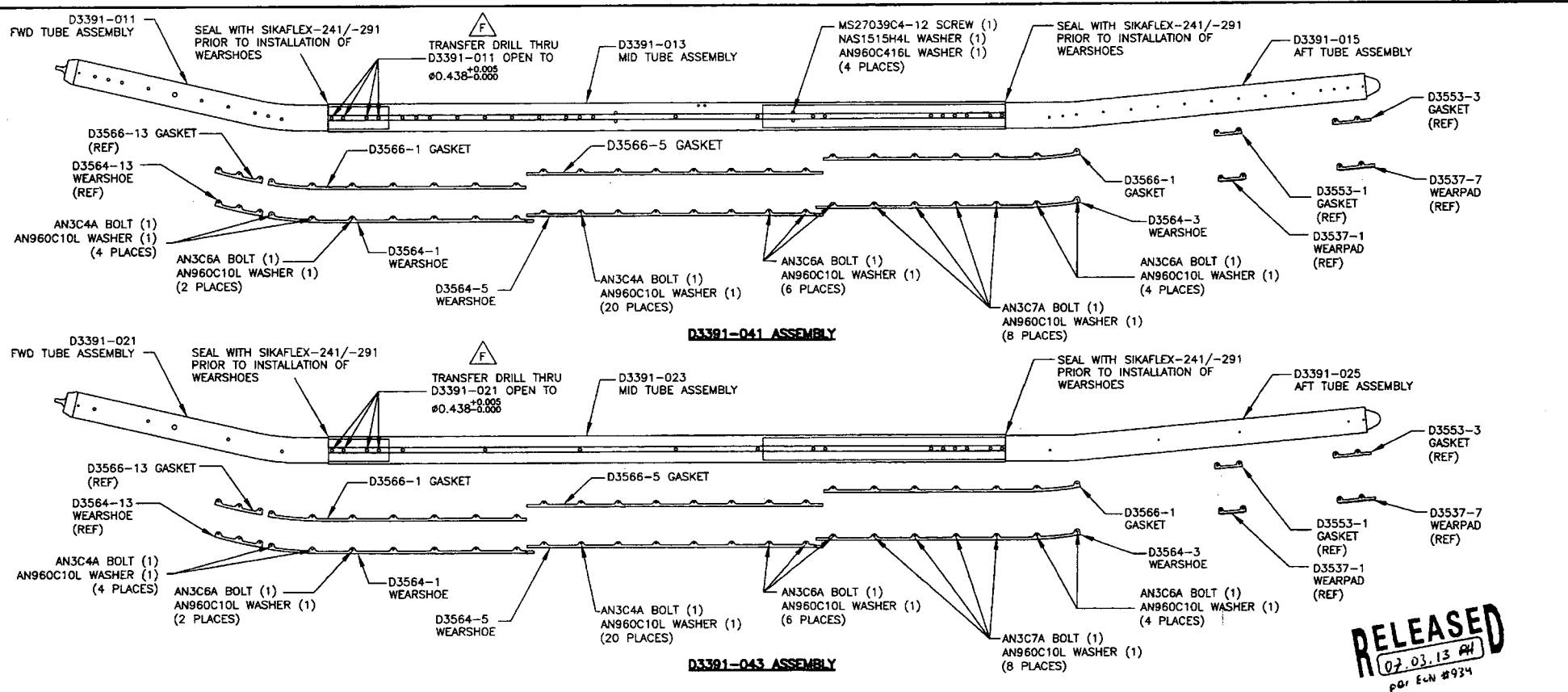
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1		D3391-021	FWD TUBE ASSEMBLY
1		D3391-023	MID TUBE ASSEMBLY
1		D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C/SINK Ø0.391/Ø0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

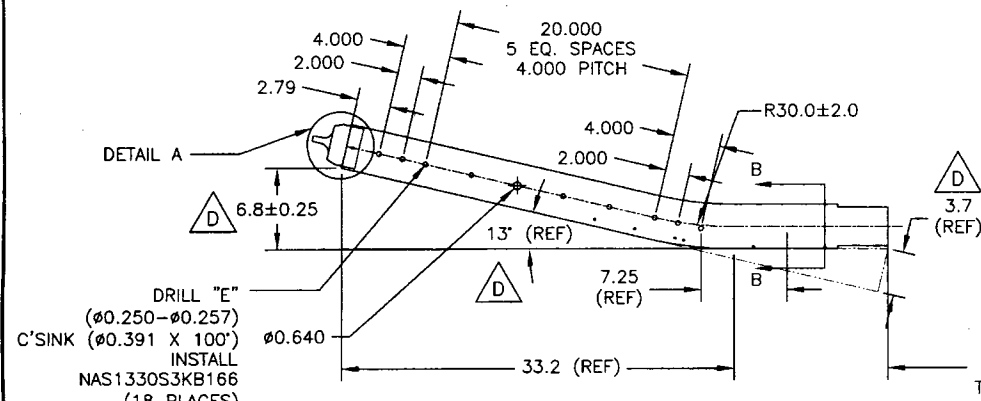
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>RH</i>	APPROVED <i>AH</i>	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 1 OF 5 SCALE NTS

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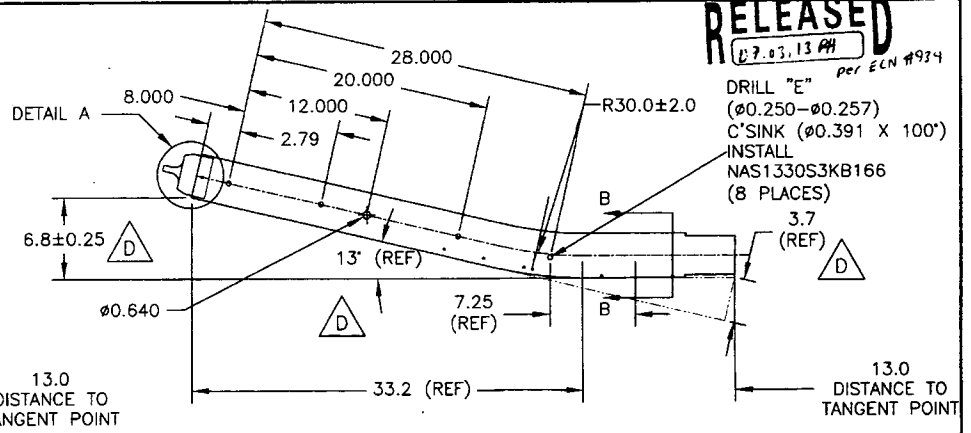
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w/03880

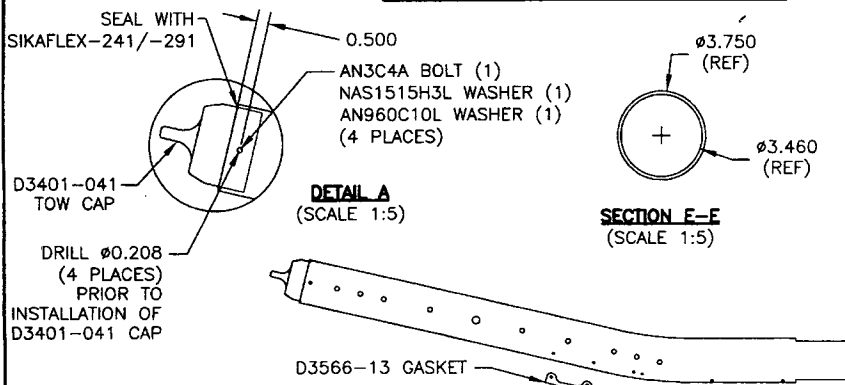
RELEASED
 07.03.13 PH
 per ECN #934



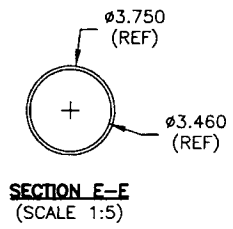
D3391-011 ASSEMBLY AND BENDING DETAIL



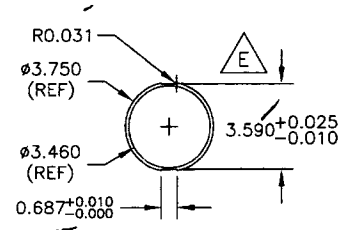
D3391-021 ASSEMBLY AND BENDING DETAIL



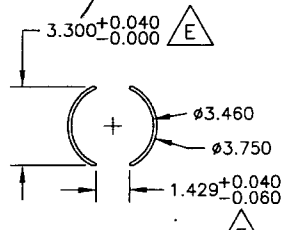
DETAIL A
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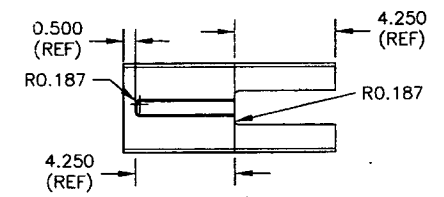
SECTION E-E
 (SCALE 1:5)



SECTION D-D
 (SCALE 1:5)

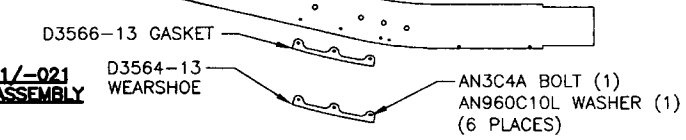


SECTION C-C
 (SCALE 1:5)



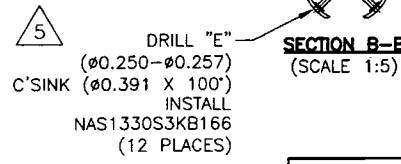
VIEW Z-Z
 (SCALE 1:5)

D3391-011/-021 WEARSHOE ASSEMBLY

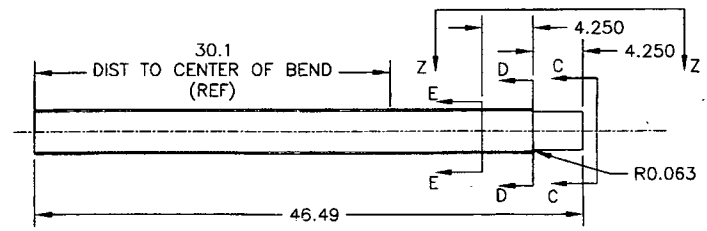


D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

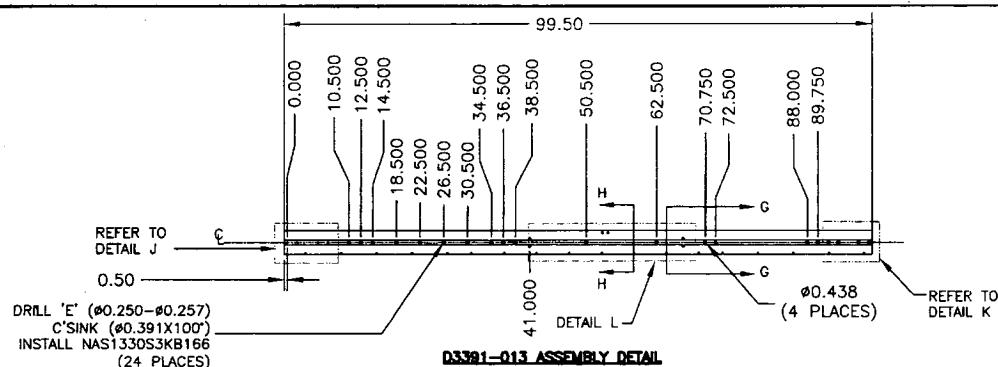


SECTION B-B
 (SCALE 1:5)

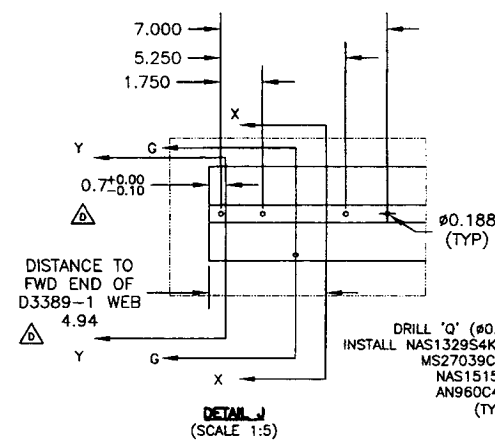


D3391-1 DRILLING AND CUTTING DETAIL
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.		DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED A	APPROVED A	DRAWING NO. D3391		REV. F SHEET 2 OF 5
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		SCALE 1:10

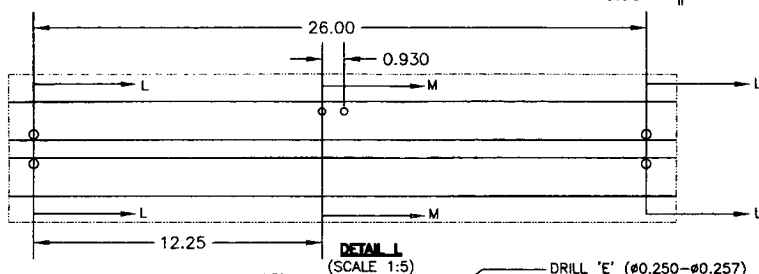


D3391-013 ASSEMBLY DETAIL

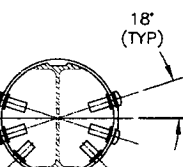


DETAIL J (SCALE 1:5)

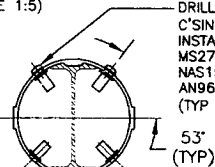
DRILL 'Q' (#0.332-#0.338)
INSTALL NAS1329S4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)



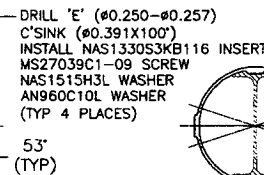
DETAIL L (SCALE 1:5)



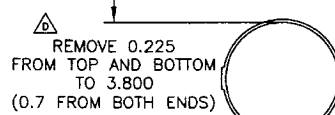
SECTION L-L (SCALE 1:4)



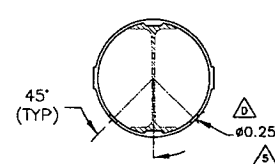
SECTION M-M (SCALE 1:4)



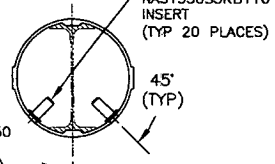
SECTION LL-LL (SCALE 1:4)



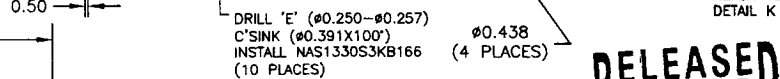
SECTION Y-Y (SCALE 1:4)



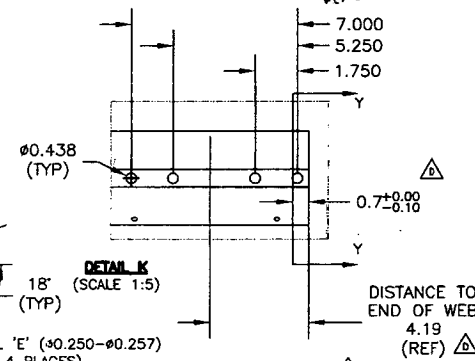
SECTION G-G (SCALE 1:4)



SECTION H-H (SCALE 1:4)



D3391-023 ASSEMBLY DETAIL



DETAIL K (SCALE 1:5)

RELEASED
07.03.13 RH
DCI E&M #934

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

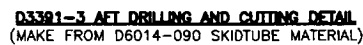
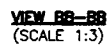
QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

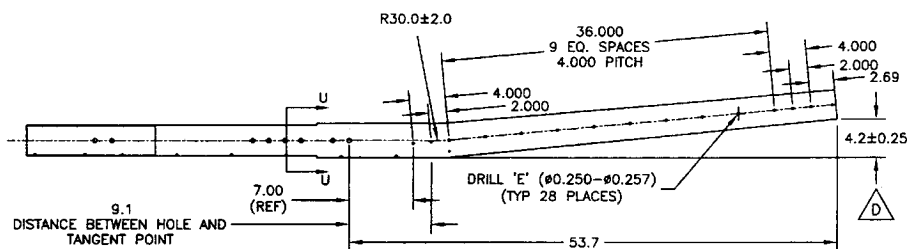
SECTION X-X (SCALE 1:2)

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CHECKED #	APPROVED #	DRAWING NO. D3391		
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 3 OF 5		SCALE 1:20

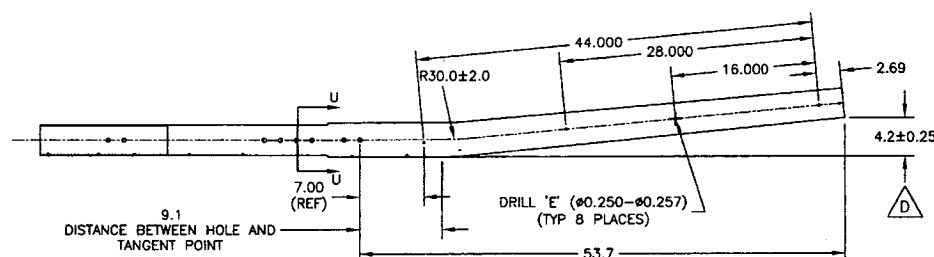


RELEASED
07.03.13 PM
PER ECL #934

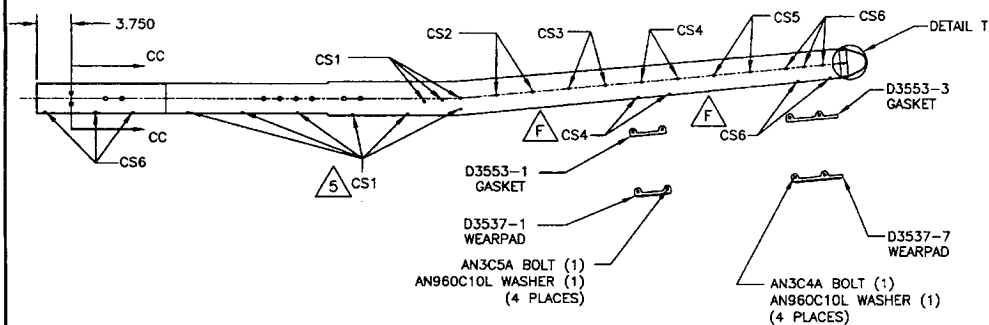
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		DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	
			REV. F SHEET 4 OF 5 SCALE	



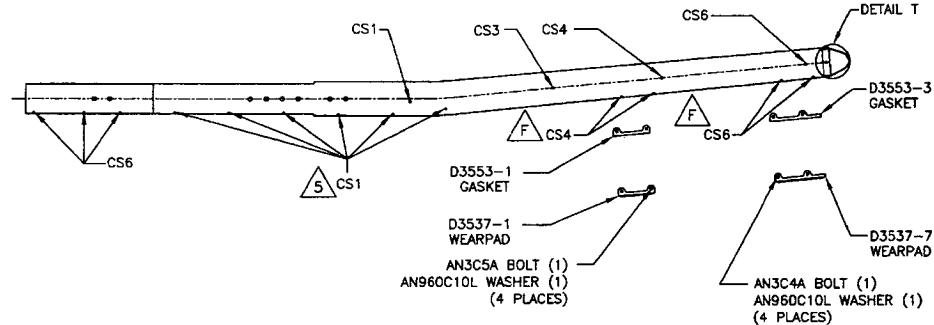
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



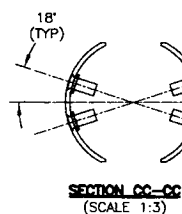
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



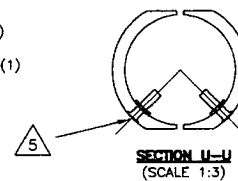
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)
DETAIL T
(SCALE 1:3)
SEAL WITH
SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DESIGN PH	DRAWN BY RH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

RELEASED
07.03.13 RH
per ELN #734

DART AEROSPACE LTD		Work Order:	31810
Description: Fwd tube assembly		Part Number:	D3391-021
Inspection Dwg: D3391 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	J.L/J.F	Audited by:	Jme	Prototype Approval:	
Date:	07/05/15	Date:	07/05/20	Date:	

Rev	Date	Change	Revised by	Approved
A	11/1/2011	New Issue	KJ/JLM	